

# Work Order ID 60500

Tuesday, July 13, 2010 10:03:57 AM



Page 1

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 7/13/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10-7-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3910

B

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut to 1.450" Long

*MJ*  
10/07/19

10

0

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: *AA*

DWG REV: *B*

DEBURR

*DT*  
10/07/20

10

*[Signature]*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DOA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 60500**

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Page 2

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Setup Start



Revision ID:

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Item Name: Crosstube Lug

Start Date: 7/13/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00				10	<del>0</del>		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				10	7		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1  Memo	0.00  0.00				10	107-21		

W/O:		WORK ORDER CHANGES						
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**Work Order ID 60500**

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Page 3

Item ID: D3910-3

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Revision ID:

Item Name: Crosstube Lug

Start Date: 7/13/2010 Start Qty: 10.00

Required Date: 7/20/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	<i>M114841</i>								
	<i>START: 8:50</i>								
	<i>COAT: 30'</i>	0.00							
	<i>FINISH: 9:20</i>								

160	QC3- Inspect Part Finish	0.00							
	<i>Memo</i>	0.00							

170	Identify as per dwg & Stock Location: <i>507</i>	0.00							
	<i>Memo</i>	0.00							

*10-7-22*

*ml 10 07 22 (10)*

*10-7-22 (10 x 5)*

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

**Work Order ID 60500**

Tuesday, July 13, 2010 10:03:57 AM

Page 4

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Revision ID:

Item Name: Crosstube Lug

Start Date: 7/13/2010 Start Qty: 10.00

Required Date: 7/20/2010 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/07/23 JG  
mf  
10-7-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, July 13, 2010 10:04:01 AM

Page 1

Work Order ID: 60500



Parent Item: D3910-3



Parent Item Name: Crosstube Lug


Start Date: 7/13/2010

Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD  
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423  Lug Extrusion		Manufactured	No			100	f	397.9378	0.13	1.368421			

Location

MAT06

43722

45800

Loc Qty

397.9377695

180

217.937769

Loc Code

ms  
10/09/19

~~1.3688~~  
1.3684

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



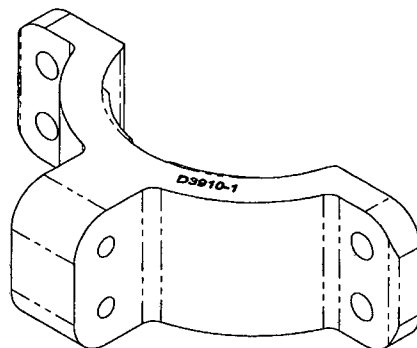
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

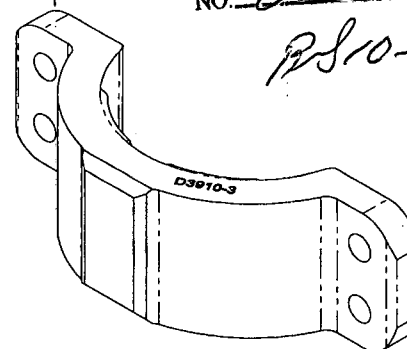
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3910-1 X-TUBE LUG**



**D3910-3 X-TUBE LUG**





SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 60500

*PS10-7-13*

**RELEASED**  
2010-03-22  
*MP*

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010  $\pm$  0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015  $\pm$  0.005
- 7) WEIGHT -1: 0.32 lbs  
-3: 0.25 lbs

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3); REASON: SEE TR-D350-807-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.	REV.	
MFG. APPR.		D3910	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		X-TUBE LUG (350)	NT	
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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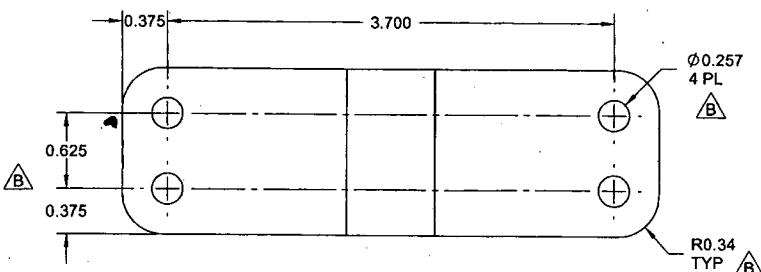
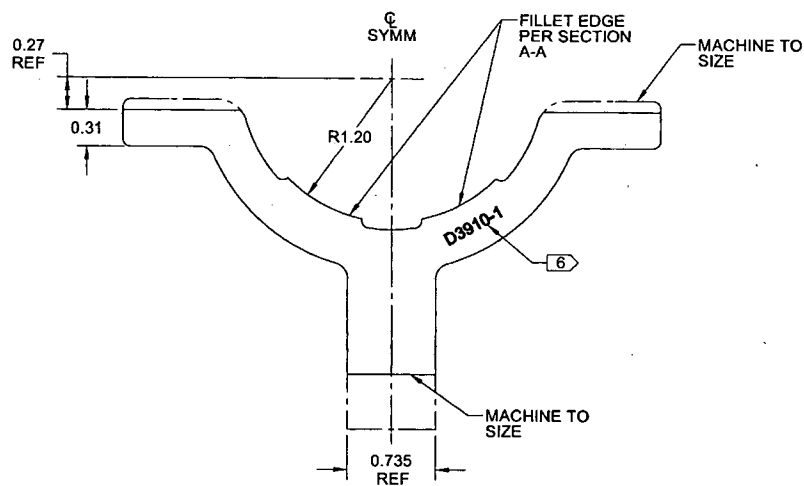
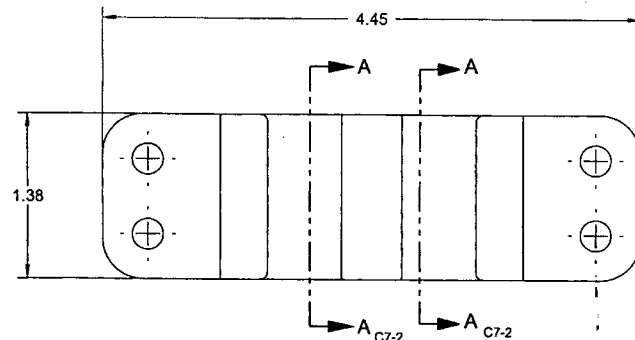
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**SECTION A-A**  
C4-2  
C5-2

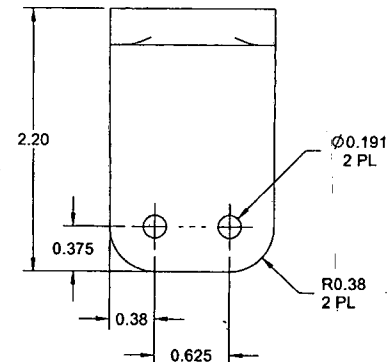


ROUND EDGE  
R0.06 MIN - R0.10 MAX  
2 PL



**D3910-1 X-TUBE LUG**

*w/o 60500*



**RELEASED**  
2010-03-22  
*MP*

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
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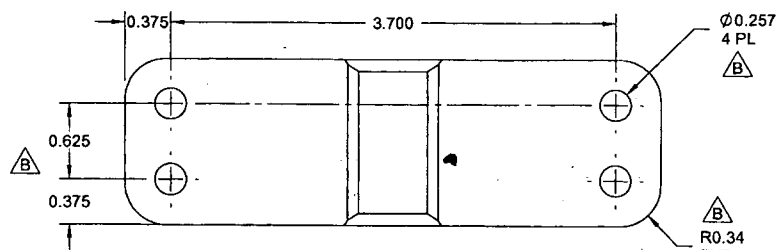
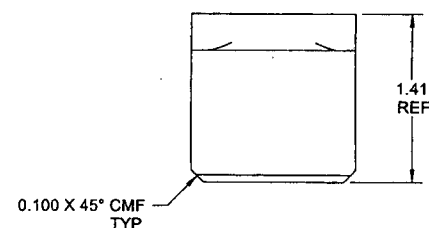
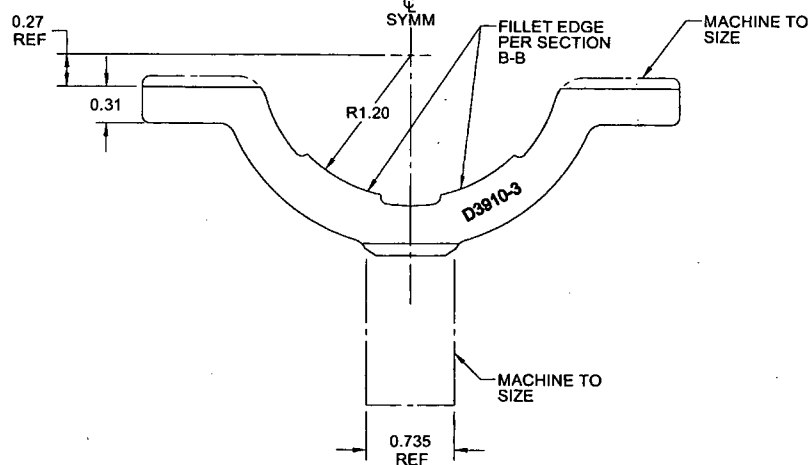
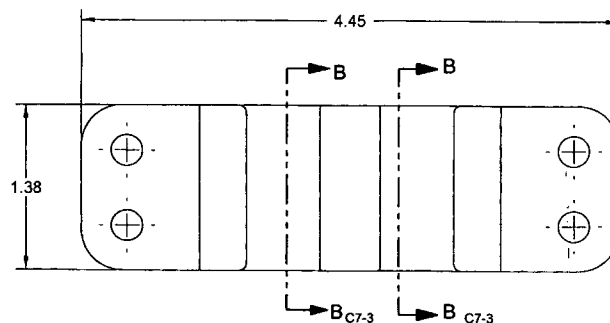
**NOTE:** Date & initial all entries





ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL

**SECTION B-B**  
C4-3  
C5-3



**D3910-3 X-TUBE LUG**

**RELEASED**  
2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 3 OF 3
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